

Date:
User:Date: Tuesday, 11/29/2005 7:12:52 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 25052
 Estimate Number : 11053
 P.O. Number : N/A
 This Issue : 11/29/2005 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run :
 Written By : Est REVA 05/09/13 AP
 Checked & Approved By : Same as Above
 Comment : Created By Auto Work Order

Drawing Name : NUT PLATE ASSEMBLY
 Part Number : D2873043
 Drawing Number : D2873 REVA
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 12/21/2005 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0375X01000 6061T6 BAR



Comment: Qty.: 0.3237 f(s)/Unit Total: 6.4743 f(s)

6061T6 BAR

Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)

(M6061T6B0.375x01.000)

Identify for D2873-3

Batch: M18250

J.G 05/12/17 20

Tools:

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: 1.000" x 0.375" x 3.700" long

J.G 05/12/17 20

Tools:

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA and Dwg D2873

Identify as D2873-3

Dwg Rev A Folio Rev A

J.G 05/12/18 20

Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 7:12:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 25052

Part Number: D2873043

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

MS21075L5

Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 60.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

3

MS21075L5

Nut Plate

1718136

Tools:

FF 06-01-05

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-043

Tools:

FF 06-01-05

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Tools:

FF 06-01-05

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 387

Tools:

1 06/01/06

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Tools:

545 06/01/10 (20)

19 06/01/09 (20)

Job Completion

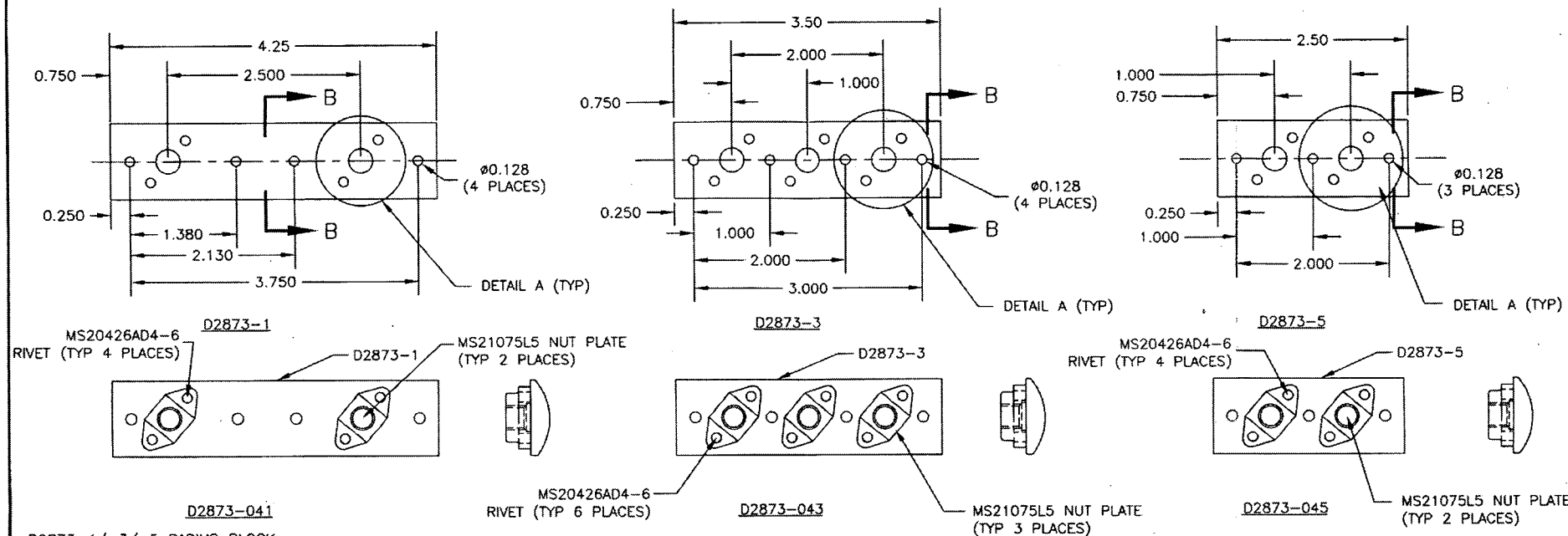


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2873-1/-3/-5 RADIUS BLOCK

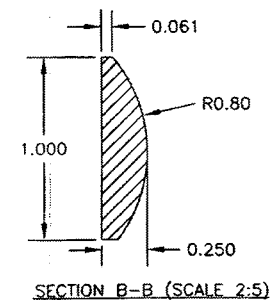
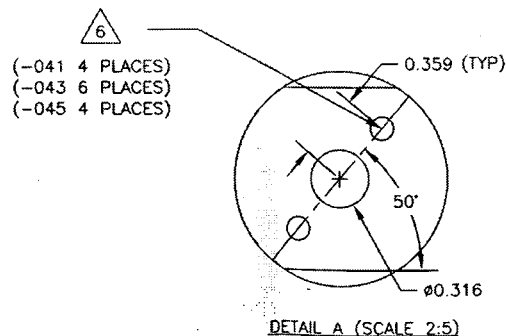
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

	-041	-043	-045	PART NUMBER	DESCRIPTION
	X			D2873-041	NUT PLATE ASSEMBLY
		X		D2873-043	NUT PLATE ASSEMBLY
			X	D2873-045	NUT PLATE ASSEMBLY
1				D2873-1	RADIUS BLOCK
	1			D2873-3	RADIUS BLOCK
			1	D2873-5	RADIUS BLOCK
4	6	4		MS20426AD4-6	RIVET
2	3	2		MS21075L5	NUT PLATE



A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

DART AEROSPACE LTD		Work Order: 250.32
Description:		Part Number: 02873-3
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.500	+/- 0.030	3.501	✓			
2.000	+/- 0.010	1.997	✓			
1.000	+/- 0.010	0.997	✓			
0.750	+/- 0.010	0.746	✓			
0.250	+/- 0.010	0.245	✓			
1.000	+/- 0.010	0.995	✓			
2.000	+/- 0.010	1.996	✓			
3.000	+/- 0.010	2.995	✓			
0.128	+0.005 -0.001	0.130	✓			
1.000	+/- 0.010	1.003	✓			
R0.800	+/- 0.010	R-800	✓			
0.061	+/- 0.010	0.060	✓			
0.250	+/- 0.010	0.249	✓			
0.316	+0.006 -0.001	0.321	✓			
0.230 x 0.125	+/- 0.010	0.230 x 0.125	✓			

Measured by: S.G.	Audited by: 36	Prototype Approval: N/A
Date: 05/12/18	Date: 05.12.18	Date: N/A.

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	